

Work Order ID 77164

77164

Page 1

November-28-11 8:59:18 AM

Item ID: D3016-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Frame Assembly
 Start Date: 28/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3016	RevA / DEO A-1								
100	Weld per dwg A/R 4130 rod Batch: <u>2118875</u>	0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut all tubes as per Dwg D3016								
	2-Deburr								
	3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597								
	4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041								
	5- Assemble brackets and gusset per dwg and weld								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110	QC								
Quality Control	Memo	0.00							

0 2-5-17

AA 12.05.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D3016-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Seat Frame Assembly
 Start Date: 28/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating									

Install paint screws on fitting ends
 START TIME: 8:00
 OVEN TEMPERATURE: 320 °F
 FINISH TIME: 8:30

140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

W 117338

41 set

1X

1

12/05/22

BR 125-22

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: 6A	0.00							
150									
Packaging	Memo W/O 77161	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/15/25
ME
12-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 77164

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Parent Item: D3016-041

D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issueECIPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4130NT0.750W.049

Purchased

No

100

f

69.8000

4.3

4.526316

M4130NT0 750W 049

4130 RD Tube .750 x.049W

**

EL 12-5-17

Location

Loc Qty

Loc Code

MAT033

69.8

118772

69.8

M4130NT0.500W.049

Purchased

No

100

f

31.8500

4.3

4.526316

M4130NT0 500W 049

4130 RD Tube .500 x.049W

**

EL 12-5-17

Location

Loc Qty

Loc Code

MAT032

31.85

110740

31.85

M4130NT1.000W.120

Purchased

No

100

f

69.2600

1.5

1.578947

M4130NT1 000W 120

4130 RD Tube 1.00 x .120wall

**

EL 12-5-17

Location

Loc Qty

Loc Code

MAT033

69.26

117656

23.42

117973

45.84

D3016-17

Manufactured

No

100

Each

28.0000

2

2

D3016-17

Gusset

**

EL 12-5-16

Location

Loc Qty

Loc Code

WA

28

70872

16

70909

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

77164

D3016-041

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3016-13

Manufactured No

100

Each

4.0000

2

2

D3016-13

Bracket

76567 X 2-

**

EL 12-5-17

Location

Loc Qty

Loc Code

WA

4

70015

4

D3016-15

Manufactured No

100

Each

5.0000

2

2

D3016-15

Gusset

77579 X 1

**

EL 12-5-17

Location

Loc Qty

Loc Code

WA

5

73541

5

D3020-1

Manufactured No

100

Each

19.0000

4

4

D3020-1

Fitting

**

EL 12-5-17

Location

Loc Qty

Loc Code

WA

19

36713

1

70873

1

76579

17

4

November-28-11 8:59:23 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 77164 M.C.5

11/11/28

DEO ATTACHED

RELEASED
01.05.30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

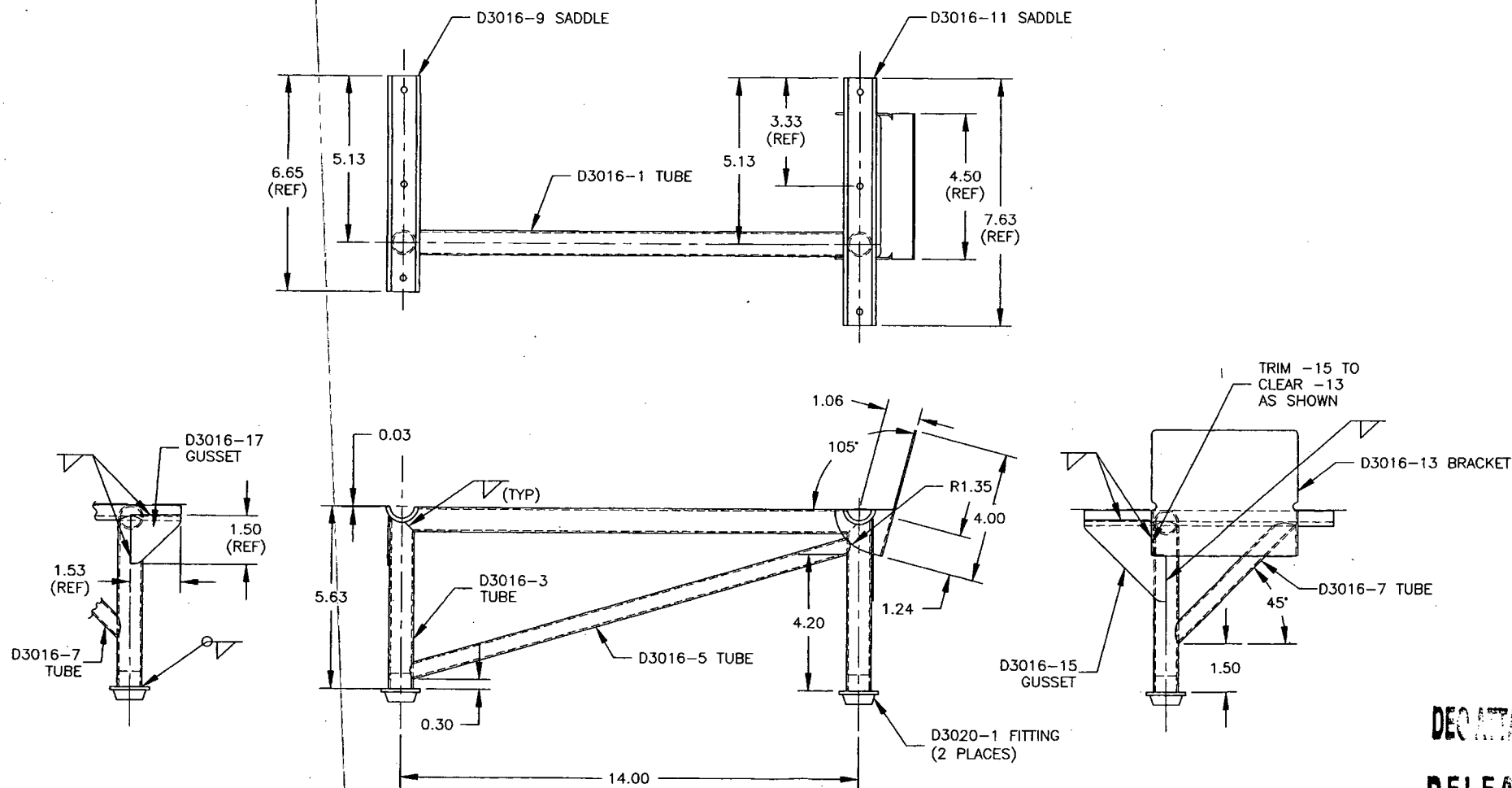
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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D3016-041 SEAT FRAME ASSEMBLY



DETACHED
RELEASED
01.05.30

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		DATE	01.05.18	TITLE		SEAT FRAME ASSEMBLY	SCALE 1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

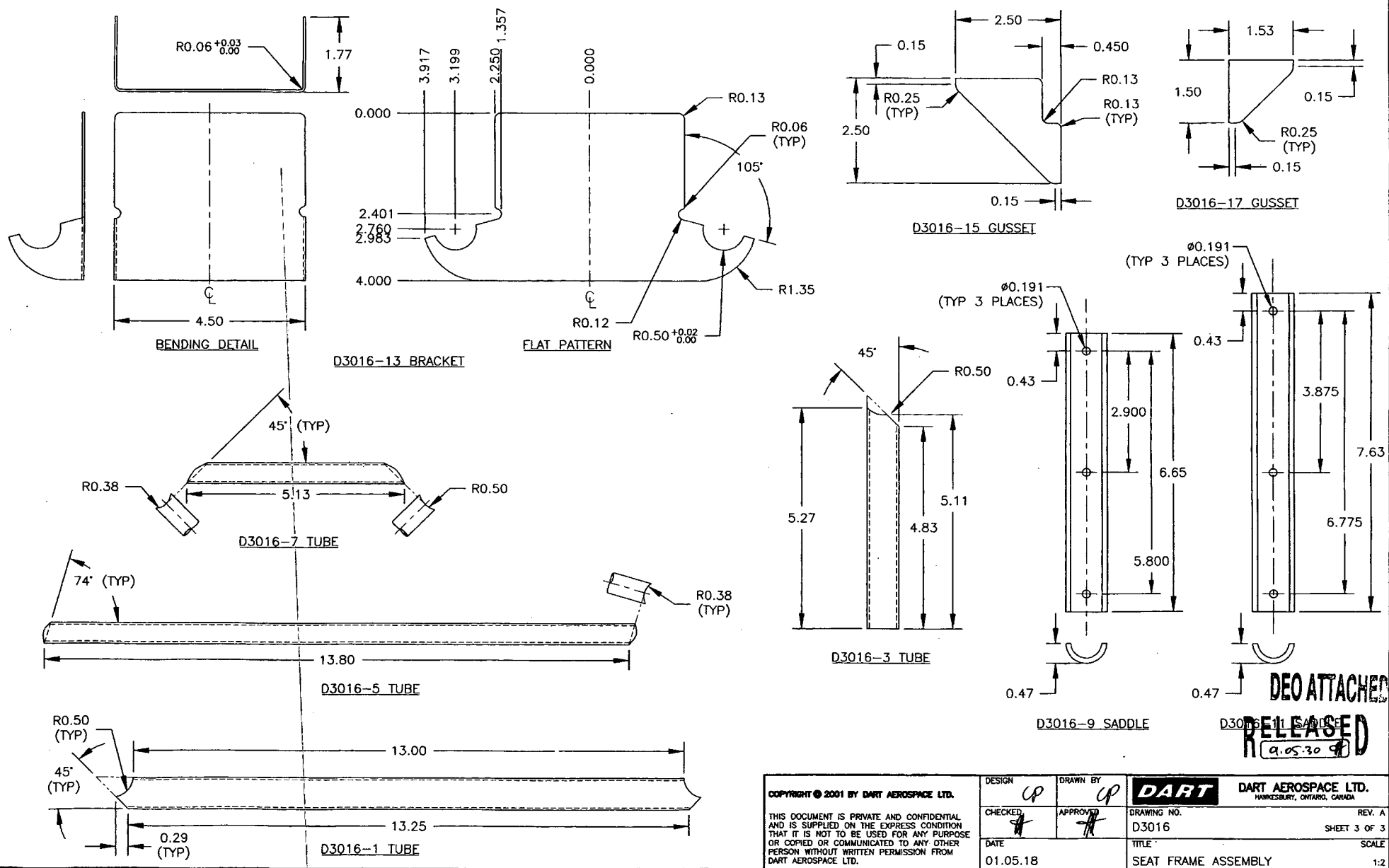
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		DATE 01.05.18	TITLE SEAT FRAME ASSEMBLY		SCALE 1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 1	CHECKED UP	MFG. APPR. R	APPROVED MP	DE APPR. H		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	

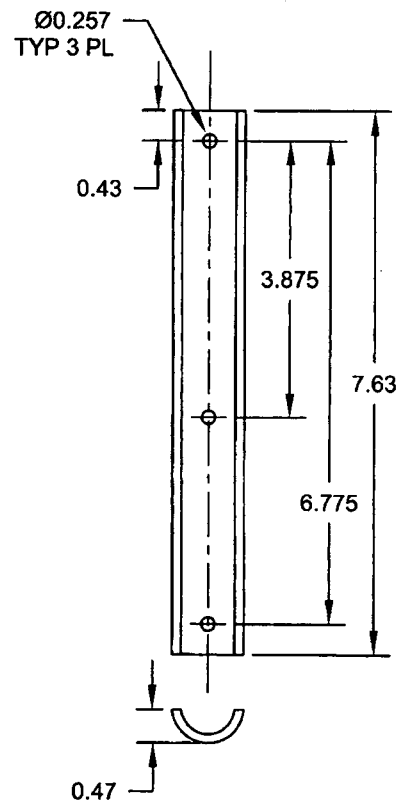
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

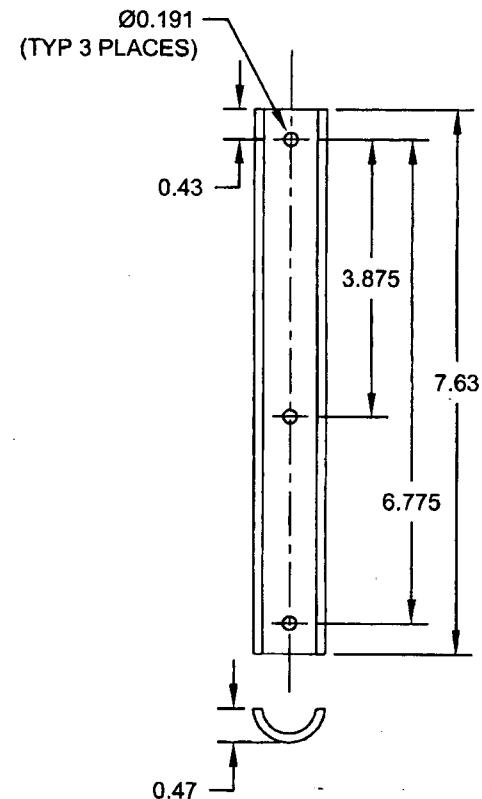
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

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